

Date: Tuesday, 4/29/2008 10:03:48 AM  
 User: David Duval

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GLARESHIELD
Job Number : 38869	
Estimate Number : 13288	
P.O. Number :	Part Number : D36901
This Issue : 4/29/2008 S.O. No. :	Drawing Number : PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : <i>R&amp;A</i> THERMOFORMING	Drawing Revision : PRELIM
Previous Run :	Material :
Written By :	Due Date : 5/23/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev A New Issue 08/04/28 DL verified by:DD	

Additional Product

FOR ENGINEERING USE ONLY

~~PROTOTYPE~~

Job Number:

PRELIMINARY ISSUE *CP 08.09.16*

Seq. #: Machine Or Operation: Description:

1.0 MLEXS093F600602 GE PLASTICS LEXAN SHEET



Comment: Qty.: 26.3110 sf(s)/Unit Total : 26.3110 sf(s)  
 GE PLASTICS LEXAN SHEET  
 batch: *M106751*

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size 69.5" X 35.5"

*OK: 08.04.29.*

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3690-1and Folio FTA 019

Dwg. Rev. - *A - Preliminary.*  
 Folio Rev. *A*

*OK 08.04.29*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

*OK. 08.04.29.**x2**PTD. →*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GLARESHIELD

Job Number: 38869

Part Number: D36901

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



BB 08/04/29



x1

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



x1

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3690

OK 08.04.29

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

OK 08.04.30

8.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08-05-07

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

FOR KIT B/N 39207

08-05-13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 Prototype 08-05-13

Job Completion



Change to  
W/O # 00235

W/O 08-05-09  
PART ACCEPTABLE  
TO D3690 Rev. C  
08-09-16

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

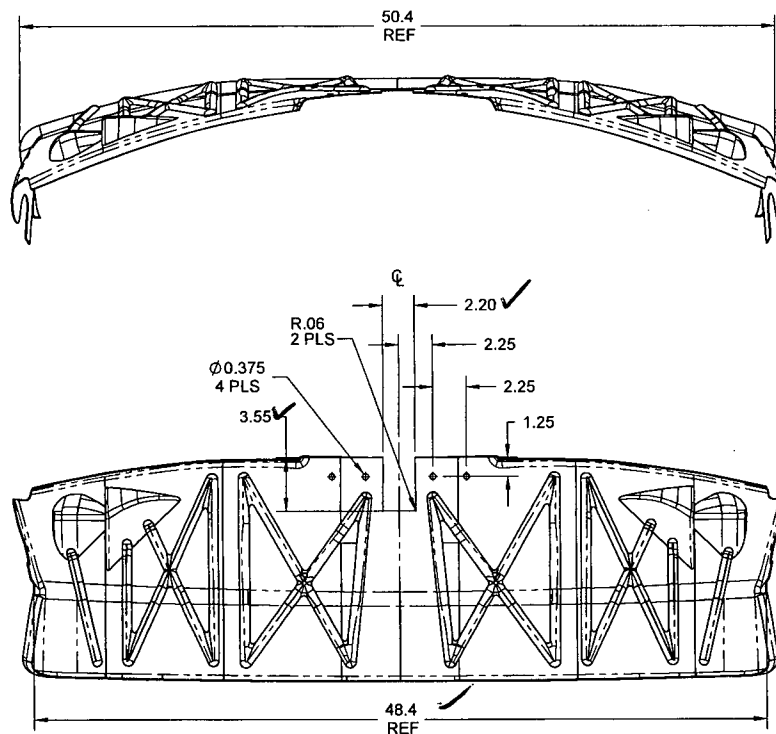
Date: 25-Apr-08

Product Name: B412 Glareshield

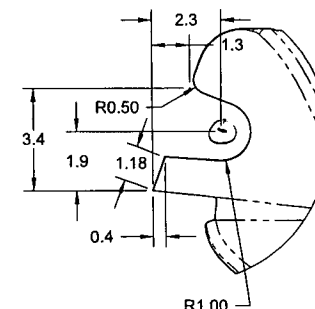
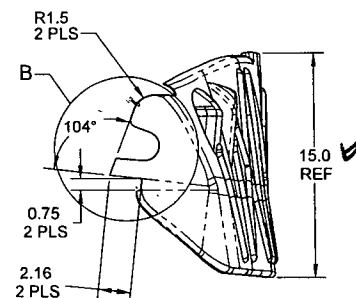
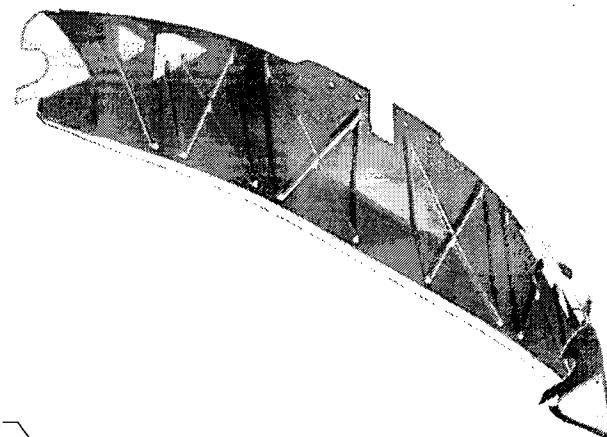
Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		



**D3690-1 GLARESHIELD**



**DETAIL B  
SCALE 1:4**

**REFERENCE ONLY**

**NOTES:**

1) MATERIAL: F6006 SUEDE/POLISHED GY5V133 BLACK FLAT LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXX.093-F6006-02)

2) TOOLING: THERMOFORM PER MOLD DT PER QSI 022  
TRIM PER MOLD DT EXCEPT WHERE NOTED

3) FINISH: NONE

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) IDENTIFICATION: NONE

8) WEIGHT: 2.5 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3690</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>GLARESHIELD ASSEMBLY</b>	1:8
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.29	4	1 unit did not form. bad seal.		Seals: replace.	Wh. 08.04.29			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	38869
Description: 412 Glare shield.	Part Number:	D36901
Inspection Dwg: D3690 Rev: A Preliminary		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	Ph
Free of visual flaws (bumps, cracks, voids, etc.)	Ph

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
50.4" Front top ✓		50.4"	✓		TAPE	
48.4" Top Center		48.4"	✓		TAPE	
2.20" Back cutout width		2.20	✓		Caliper	
3.55" Back cutout depth		3.56	✓		Caliper	
15.0 Top Front to back		15.0	✓		TAPE	

Measured by: Ph.	Audited by:	Prototype Approval:
Date: 08.04.30.	Date:	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		

# Receiving Report

Date: 8/01/09

Batch No: M106751

Supplier: SABIC

Dart P/O: 5333

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection 08/01/09 N/A ☒  
 Work Order                     

Discrepancies				Quantity Received	Quantity Returned	Quantity Short	Comments
Part Number	Description	Quantity Ordered					

Initials of receiver (if shipment OK)                      Level 12                     

Production/Admin:                       
 Date: 08/01/09  
 Received/Costing: RLC 6697  
 Initial: RL

Location PARYL

H:\FORMS\Purchasing\approved\urch\RECREPORT F / D

Comments:

SABIC  
INTEGRATING  
PLASTICS

سابك  
sabic

***SABIC Polymershapes***

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

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## **CERTIFICATE OF COMPLIANCE**

SOLD TO: DART AEROSPACE

DATE: 1/9/2008

YOUR PURCHASE ORDER : 00005333

OUR SHIPPER NO: 080434

LINE ITEM # : 1

QUANTITY: 56

DESCRIPTION: F6006-701 LEXAN BLACK .093 X 52 X 97

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE



JON CALDWELL  
BRANCH MANAGER